

Chapter ATCP 81

CHEESE GRADING, PACKAGING AND LABELING

Subchapter I — Definitions

ATCP 81.01 Definitions.

Subchapter II — Grading and Marking Requirements; General

ATCP 81.20 Wisconsin cheese; manufacturer's label.

ATCP 81.21 Labeling cheese from other states or foreign countries.

ATCP 81.215 Age labeling of cheese.

ATCP 81.22 Cheese grades and grade labels.

ATCP 81.23 Cheese grading.

ATCP 81.24 Cheese grade labeling of retail packages.

ATCP 81.25 Recordkeeping.

Subchapter III — Cheese Styles, Boxes and Hoops

ATCP 81.30 Cheese styles.

ATCP 81.31 Cheese container requirements.

Subchapter IV — Cheddar, Granular and Washed Curd Cheese; Grade Standards

ATCP 81.40 Wisconsin certified premium grade AA standards.

ATCP 81.41 Wisconsin grade A or Wisconsin state brand standards.

ATCP 81.42 Wisconsin grade B standards.

Subchapter V — Colby and Monterey (Jack) Cheese; Grade Standards

ATCP 81.50 Wisconsin certified premium grade AA standards.

ATCP 81.51 Wisconsin grade A or Wisconsin state brand standards.

ATCP 81.52 Wisconsin grade B standards.

Subchapter VI — Brick and Muenster Cheese; Grade Standards

ATCP 81.60 Wisconsin certified premium grade AA standards.

ATCP 81.61 Wisconsin grade A or Wisconsin state brand standards.

ATCP 81.62 Wisconsin grade B standards.

Subchapter VII — Swiss or Emmentaler Cheese; Grade Standards

ATCP 81.70 Wisconsin grade A or Wisconsin state brand standards.

ATCP 81.71 Wisconsin grade B standards.

ATCP 81.72 Wisconsin grade C standards.

ATCP 81.73 Wisconsin grade D standards.

Subchapter VIII — Wisconsin Cheese Logotype

ATCP 81.80 Official logotype design and use.

ATCP 81.81 Registration.

ATCP 81.82 Official logotype use.

ATCP 81.83 Records.

Subchapter IX — Baby Swiss Cheese; Standard of Identity and Labeling

ATCP 81.91 Baby Swiss cheese; product description and preparation.

ATCP 81.92 Ingredients.

ATCP 81.93 Nomenclature and label declaration.

Note: Chapter Ag 81 as it existed on June 30, 1978 was repealed and a new chapter Ag 81 was created effective July 1, 1978. Chapters Ag 81 to 84 as they existed on April, 30, 1993 were repealed and a new chapter ATCP 81 was created effective May 1, 1993.

Subchapter I — Definitions

ATCP 81.01 Definitions. As used in this chapter:

(2) "Body and texture characteristics" for purposes of grading cheese under this chapter include the following traits:

(a) "Broken down" means the condition of the cheese has changed from a firm, smooth or coarse, curdy or rubbery condition to a waxy condition similar to that of cold butter, or to a mealy or pasty condition.

(b) "Coarse" means a cheese is rough, dry and sandy to the touch.

(c) "Corky" means a cheese texture that is hard, tough and overly firm and is characterized by failure of the cheese to readily break down when rubbed between the thumb and fingers.

(d) "Crumbly" means that cheese is loosely knit and tends to fall apart when rubbed between the thumb and fingers.

(e) "Curdy" means a cheese is smooth but firm, and when worked between the fingers, is rubbery and not waxy.

(f) "Firm" means the body of the cheese feels solid and is not soft or weak.

(g) "Gassy" means that cheese contains gas holes of various sizes which may be scattered or unevenly distributed throughout the cheese.

(h) "Mealy" means cheese has a short body texture, does not mold well, and looks and feels like corn meal when rubbed between the thumb and fingers.

(i) "Open" means that irregularly shaped mechanical openings, caused by workmanship and not gas fermentation, are present.

(j) "Pasty" means that cheese has a weak body, and that it becomes sticky and smeary when rubbed between the thumb and fingers.

(k) "Pinny" means the presence of numerous and very small gas holes in a cheese.

(L) "Reasonably firm" means the body of the cheese is somewhat less than firm, but not to the extent of materially injuring the keeping quality of the cheese.

(m) "Short" means that there is no elasticity to the cheese plug removed by means of a grading trier, and that the plug tends toward mealiness when rubbed between the thumb and fingers.

(n) "Slitty" means that cheese contains narrow, elongated slits which are generally associated with a cheese that is "gassy" or "yeasty". Slits in cheese having this characteristic may sometimes be referred to as "fish eyes".

(o) "Smooth" means the surface of the cheese feels silky, and is not dry, coarse or rough.

(p) "Solid, compact and close" means the texture of the cheese has practically no openings of any kind.

(q) "Sweet holes" means that small spherical gas holes, approximately the size of BB shots, are present. Sweet holes may also be referred to as "shot" or "Swiss holes".

(r) "Translucent" means a cheese has the appearance of being partially transparent.

(s) "Waxy" means that a cheese, when worked between the fingers, molds well like wax or cold butter.

(t) "Weak" means a cheese requires little pressure to crush and is soft but not necessarily sticky like a pasty cheese.

(3) "Cheese" means a dairy product prepared from the pressed curd of milk and includes the following varieties with or without rind formation:

(a) Brick or muenster cheese.

(b) Cheddar.

(c) Colby.

(d) Granular.

(e) Monterey (Jack) cheese.

(f) Swiss cheese.

(g) Washed curd.

(4) "Cheese box" means any wood, fiber, corrugated metal, plastic, fiberglass, or veneer container used as a receptacle for cheese.

(5) "Cheese hoop" means a form used to mold any of the various styles of cheese described under s. ATCP 81.30.

(6) "Cheese style" means the shape, size and weight of a manufactured unit of cheese which conforms to the standards for the particular style under s. ATCP 81.30.

(7) "Code number 55" means the code number, established as part of the uniform national coding system under P. L. 89-306,

which indicates that a particular lot of cheese was manufactured at a dairy plant in Wisconsin.

Note: The numerical national uniform coding system was developed under P. L. 89-306 and is recommended for use by the Ninth National Conference on Interstate Milk Shipments.

(8) "Color characteristics" for purposes of grading cheese under this chapter include the following traits:

(a) "Acid-cut" means a bleached or faded appearance which sometimes varies throughout the cheese but is present most often around mechanical openings.

(b) "Bleached surface" means that a faded color begins at the surface of the cheese and progresses inward.

(c) "Dull or faded" means that the color of the cheese lacks lustre or translucency.

(d) "Mottled" means the presence of irregular shaped spots or blotches in which portions of the cheese are light colored and others are darker in color, or an unevenness of color due to mixing or combining the curd from 2 different vats.

(e) "Salt spots" means the presence of large light-colored spots or areas.

(f) "Seamy" means the presence of white thread-like lines that form if the pieces of curd are not properly joined together.

(g) "Tiny white specks" means that specks resembling grains of salt, and generally associated with aged cheese, are scattered throughout the cheese.

(h) "Unattractive" means an abnormal or unappetizing appearance.

(i) "Uncolored" means the absence of any artificial coloring.

(j) "Unnatural" means the presence of a deep orange or reddish color.

(k) "Wavy" means an unevenness of color which appears as layers or waves in the cheese.

(9) "Department" means the state of Wisconsin department of agriculture, trade and consumer protection.

(10) "Diameter" means the measurement of the diameter at the larger end of cylindrically shaped cheese.

(10m) "Eye and texture characteristics" includes the following traits, for purposes of Swiss cheese grading under this chapter:

(a) "Afterset" means that there are small eyes caused by secondary fermentation.

(b) "Blind" means that no eyes are formed.

(c) "Cabbage" means that there are so many eyes in most of the cheese that the eyes crowd each other and leave only a paper-thin layer of cheese between eyes, causing the cheese to have a cabbage appearance and very irregular eyes.

(d) "Checks" means that there are small, short cracks within the body of the cheese.

(e) "Collapsed" means that eyes are improperly formed, so that they appear flattened or buckled rather than round or slightly oval.

(f) "Dead" means that eyes have completely lost their glossy or velvety appearance.

(g) "Dull" means that eyes have lost some of their bright shiny lustre.

(h) "Frog mouth" means that eyes are lenticular or spindle-shaped.

(i) "Irregular" means that eyes are not properly formed as round or slightly oval openings, but are not accurately described by other terms under this subsection.

(j) "Large eyed" means that a majority of eyes are more than $13/16$ inch in diameter. "Large eyed" includes all the following:

1. "Slight large eyed" means that a majority of eyes are more than $13/16$ inch but less than one inch in diameter.

2. "Definite large eyed" means that a majority of eyes are more than one inch in diameter.

(k) "Nesty" means that, in localized areas, there are too many small eyes.

(L) "One sided" means that eyes are reasonably developed on one side of the cheese and underdeveloped on the other.

(m) "Overset" means that there are too many eyes.

(n) "Picks" means that there are small irregular or ragged openings in the body of the cheese.

(o) "Relatively uniform eye size" means that the majority of eyes are within the size range specified in s. ATCP 81.70 (3), and that the difference in diameter between the smallest and largest of that majority of eyes is not more than $1/4$ inch.

(p) "Rough" means that eyes do not have smooth, even walls.

(q) "Shell" means that eyes have wall surfaces that look like rough-shelled nuts.

(r) "Small eyed" means that a majority of eyes are less than $3/8$ inch in diameter. "Small eyed" includes all the following:

1. "Slight small eyed" means that a majority of eyes are less than $3/8$ inch but more than $1/8$ inch in diameter.

2. "Definite small eyed" means that a majority of eyes are less than $1/8$ inch in diameter.

(s) "Splits" means that the body of the cheese contains sizable cracks, usually in parallel layers and usually clean cut.

(t) "Streuble" means that there are too many small eyes just under the surface of the cheese.

(u) "Underset" means that there are too few eyes in the cheese.

(v) "Uneven" means eyes are reasonably developed in some areas and underdeveloped in others.

(11) "Finish and appearance characteristics" for purposes of grading cheese under this chapter include the following traits:

(a) "Bandage evenly placed" means that a cheese is uniformly wrapped in cheesecloth with approximately one inch overlapping of the edges.

(b) "Burst or torn bandage" means a severance or other snag or break in the cheese cloth wrap used in the manufacture of certain cheese styles, usually occurring at the side seam.

(c) "Checked rind" or "curd openings" means the presence of numerous small cracks or breaks in the rind, sometimes following the outline of curd particles.

(d) "Cracks in the rind" means the presence of openings or breaks in the cheese rind.

(e) "Defective coating" means any of the following conditions in the wax or paraffin coating:

1. Brittle coating of paraffin that breaks and peels off in the form of scales or flakes.

2. Flat or raised blisters or bubbles under the surface of the paraffin.

3. Checked paraffin, including cracks, breaks or hairline checks in the paraffin coating on the cheese.

(f) "Firm, sound rind" means that the external surface of the cheese is firm and thick consistent with the size of the cheese; is not easily dented or damaged; is dry, smooth and closely knit to protect the interior quality from external defects; and is externally free from checks, cracks, breaks or soft spots.

(g) "High edge" means the cheese has, on its follower side, a rim or ridge which is raised in varying degrees or, in extreme cases, bent over.

(h) "Huffed" means that a cheese is swollen because of gas fermentation and has become rounded oval in shape rather than flat.

(i) "Irregular bandaging" means an overlapping, wrinkled and loose fitting bandage caused when the cheesecloth wrap is improperly placed in the cheese hoop, resulting in too much bandage on one end and an insufficient amount on the opposite end.

(j) "Lopsided" means the cheese style is asymmetrical or higher on one side than on the other side.

(k) "Mold under bandage and paraffin" means that spots or areas of mold have formed under the paraffin, or that mold has penetrated from the surface to the interior and continued to develop.

(L) "Mold under wrapper or covering" means that spots or areas of mold have formed under the wrapper or on the cheese.

(m) "Rind" means a hard coating caused by desiccation of the surface of the cheese.

(n) "Rind rot" means the presence of soft spots on the rind which have become discolored and have decayed or decomposed.

(o) "Rough surface" means the exterior of the cheese lacks smoothness.

(p) "Smooth, bright surface" means a clean, glossy exterior cheese surface.

(q) "Smooth surface" means a cheese surface which is not rough or uneven.

(r) "Soft spots" means areas on the exterior of the cheese which are soft to the touch and are also usually faded and moist.

(s) "Soiled surface" means a cheese surface containing milk-stone, rust spots or other discoloration.

(t) "Sour rind" means a fermented rind condition which is usually confined to the faces of the cheese.

(u) "Surface mold" means mold occurring on the paraffin or exterior surface of the cheese.

(v) "Wax or paraffin" means a uniform coating of wax or paraffin that adheres firmly to the surface of the cheese, which may either be thin or thick, but which has no indication of cracking, breaking or loosening.

(w) "Weak rind" means that the exterior of a cheese is thin and possesses little or no resistance to pressure.

(x) "Wet rind" means that moisture adheres to the surface of the rind. It may or may not soften the rind or cause discoloration.

(y) "Wrapper or covering" means a plastic film or foil wrap which completely covers and seals the surface of a cheese, and which adheres sufficiently to prevent or protect against the growth of mold.

(12) "Flavor characteristics" for purposes of grading cheese under this chapter include the following traits:

(a) "Acid" means the cheese is sharp and puckery to the taste or has a taste which is characteristic of lactic acid.

(b) "Barny" means a flavor trait characteristic of the odor of a milking barn, stable or cow yard.

(c) "Bitter" means a distasteful flavor characteristic of quinine which is most frequently found in aged cheese varieties.

(d) "Feed" means the presence of one or more feed flavors such as alfalfa, sweet clover, silage or similar feed, carried through from the milk used in the manufacture of the cheese into the finished product.

(e) "Flat" means an insipid flavor or one which is practically devoid of any characteristic cheese flavor for the applicable variety.

(f) "Fruity" means a sweet, fruit-like flavor resembling apples which generally increases in intensity as a cheese ages.

(g) "Lacking in flavor development" means the cheese contains no undesirable flavor and very little, if any, characteristic cheese flavor development.

(h) "Lipase" or "rancid" means a bitter or disagreeable taste or odor suggestive of butyric acid and derived from decomposed milk fat.

(i) "Malty" means the presence of a distinctive harsh flavor suggestive of malt.

(j) "Metallic" means a flavor trait suggestive of metal that imparts to the mouth a puckery sensation.

(k) "Old milk" means a cheese flavor indicating a lack of freshness in the milk used in manufacturing the cheese.

(L) "Onion" means the flavor which is characteristic of the taste and aroma suggested by its name and is present when cows producing milk used in the manufacture of cheese have eaten onions, garlic or leeks.

(m) "Sour" means a pungent acidic flavor resembling vinegar.

(n) "Sulfide" means the presence of an objectionable flavor of hydrogen sulfide and is similar to the flavor of water having a high sulfur content.

(o) "Utensil" means a flavor suggestive of improper or inadequate washing and sterilization of milking machines, utensils or dairy plant equipment.

(p) "Weedy" means a taste characteristic due to the use of milk possessing an essence of common weeds, which is generally present when cows eat weedy hay or graze on weed-infested pastures.

(q) "Whey-tainted" means a slight acidic flavor and odor characteristic of fermented whey caused by too slowly or incompletely expelling the whey from the curd.

(r) "Yeasty" means a flavor indicating the presence of yeast fermentation in the manufacture of the cheese.

(13) "Grade attributes" for purposes of grading cheese under this chapter include the following degrees for a particular trait, which signify the relative absence or presence of the indicated trait:

(a) "Definite" means the trait is not intense but is detectable in the cheese being graded.

(b) "Pronounced" means the trait is sufficiently intense as to be easily identified in the cheese being graded.

(c) "Slight" means the trait is detected only upon critical examination.

(d) "Very slight" means the trait is detected only upon very critical examination.

(14) "Grader" means a person licensed by the department under s. 97.17, Stats., to grade cheese.

(15) "Official logotype" means an identifying trademark or symbol, as prescribed in subch. VIII, which may be stamped, imprinted on, affixed to, or made a part of any label of cheese manufactured in this state to identify or distinguish it as being "100% Wisconsin cheese".

(16) "Scale board" means a flat piece of wood or veneer placed in the cheese box or container to protect the cheese from damage.

History: Cr. Register, April, 1993, No. 448, eff. 5-1-93; r. (1), Register, January, 1996, No. 481, eff. 2-1-96; CR 01-057: cr. (10m), Register June 2002 No. 558, eff. 7-1-02.

Subchapter II —Grading and Marking Requirements; General

ATCP 81.20 Wisconsin cheese; manufacturer's label. All cheese manufactured in this state shall be labeled at the dairy plant or cheese factory with all of the items listed under subs. (1) to (5). The labeling shall remain on the cheese until the cheese is used in the manufacture or processing of another food, or until it is relabeled by a buyer who cuts and repackages the bulk unit into consumer size packages. A manufacturer may not use electronic code labeling as the sole means to display labeling required under this section, except when the cheese is under the manufacturer's custody and control. If a manufacturer uses electronic code labeling, the manufacturer shall provide a scanner or other device that enables a department employee or agent to decode the information into a readable format at the place where the manufacturer keeps the cheese.

(1) NAME OF CHEESE. The name of the cheese variety or type of cheese.

(2) STATE IDENTIFICATION. The word "WISCONSIN" or code number "55", a numerical code which indicates that the cheese was manufactured at a dairy plant in this state.

(3) **DAIRY PLANT IDENTIFICATION.** The serial or individual identification number assigned by the department for the dairy plant at which the cheese was made.

(4) **DATE OF MANUFACTURE.** The month, date and year of manufacture for the cheese. The date of manufacture may be abbreviated using an alphanumeric or all numeric format. The abbreviation shall clearly identify the month, date and year, or a Julian calendar date consisting of a 2 digit designation for the year of manufacture followed by a 3 digit Julian date.

(5) **VAT IDENTIFICATION.** The alpha or numerical designation of the vat which identifies a specific vat or chronological sequence of manufacture when more than one vat of cheese is manufactured in the same vat on the same day.

Note: A manufacturer's label will substantially comply with this subsection if it uses one of the following alternative formats for each label requirement under subs. (1) to (5):

| TYPE OF CHEESE | TYPE OF CHEESE | TYPE OF CHEESE | TYPE OF CHEESE |
|----------------|----------------|----------------|----------------|
| WISCONSIN | WISCONSIN | 55-1402 VAT A | 55-1402 VAT A |
| 1402 VAT A | 1402 VAT A | 12-9-90 | 90/343 |
| DEC 9 90 | 12-9-90 | | |

History: Cr. Register, April, 1993, No. 448, eff. 5-1-93; cr. (6), Register, January, 1996, No. 481, eff. 2-1-96; CR 99-151: am. (intro.) and (4) and r. (6), Register July 2001, No. 547 eff. 8-1-01.

ATCP 81.21 Labeling cheese from other states or foreign countries. (1) **MANUFACTURER'S LABEL.** (a) *General requirements.* If cheese from other states or foreign countries is received in Wisconsin for further packaging or distribution, the cheese shall be plainly labeled or identified under par. (b) or (c). The label shall appear on the outside container or receptacle in which the cheese is received in this state.

(b) *Out-of-state identification.* Cheese originating from states other than Wisconsin shall be identified by all of the following:

1. The name of the cheese variety or type of cheese.
2. Identification by name or numerical code of the state of manufacture or origin. If code number identification is used, the number shall be the 2 digit code number assigned for individual states by the National Conference of Interstate Milk Shipments.
3. The dairy plant serial number assigned by the state licensing agency to the dairy plant in which the cheese was manufactured.

(c) *Foreign country identification.* Cheese originating from a foreign country shall be identified with both of the following:

1. The name of the cheese variety or type of cheese.
2. The name of the foreign country in which the cheese was manufactured.

(2) **WISCONSIN GRADE LABELING PROHIBITED.** No person may use any Wisconsin grade mark or Wisconsin grade label designation on cheese manufactured in another state or country.

History: Cr. Register, April, 1993, No. 448, eff. 5-1-93; correction in (1) (a) 2. made under s. 13.93 (2m) (b) 7., Stats., Register, May, 1999, No. 521; CR 99-151: r. and recr. (2), Register July 2001, No. 547 eff. 8-1-01.

ATCP 81.215 Age labeling of cheese. If the label on any bulk cheese or retail package of cheese states that the cheese is "aged" or "cured," the label shall state the minimum length of time in days, months or years that the cheese has been aged or cured since it was manufactured.

History: CR 99-151: cr. Register July 2001, No. 547 eff. 8-1-01.

ATCP 81.22 Cheese grades and grade labels. (1) **GRADES.** Cheese manufactured and sold in this state shall be graded or identified in one of the following categories, according to the grade standards applicable to the particular cheese variety in subchs. IV to VII, if there is a Wisconsin grade standard for that variety in subchs. IV to VII:

- (a) Wisconsin certified premium grade AA.
- (b) Wisconsin grade A or Wisconsin state brand.
- (c) Wisconsin grade B.

- (d) Wisconsin grade C for Swiss cheese.
- (e) Wisconsin grade D for Swiss cheese.
- (f) Undergrade.
- (g) Not graded.

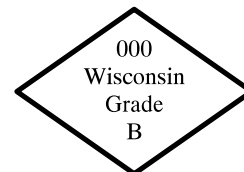
(2) **GRADE MARK OR LABEL SPECIFICATIONS.** (a) *Wisconsin certified premium grade AA, Wisconsin grade A, or Wisconsin state brand.* The grade mark for cheese grades under sub. (1) (a) or (b) shall consist of a miniature outline map of the boundaries of Wisconsin with the cheese grader's license number and the name of the applicable grade, as determined by the cheese grader, enclosed within the outline map. The type shall be spaced and designed so as to be legible and present a symmetrical appearance.

Note: The following are illustrations of the grade mark requirements under s. ATCP 81.22(2)(a):



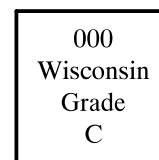
(b) *Wisconsin grade B.* The grade mark for cheese graded as Wisconsin grade B shall consist of a diamond-shaped figure with the grader's license number and the words "Wisconsin grade B" enclosed with the border. The type shall be spaced and designed so as to be legible and present a symmetrical appearance.

Note: The following is an illustration of the grade mark requirements under s. ATCP 81.22 (2) (b).



(c) *Wisconsin grade C.* The grade mark for cheese graded as Wisconsin grade C shall consist of approximately a 1 inch square with the grader's license number and the words "Wisconsin grade C" enclosed within the square. The type shall be spaced and designed so as to be legible and present a symmetrical appearance.

Note: The following is an illustration of the grade mark requirements under s. ATCP 81.22 (2) (c).



(d) *Wisconsin grade D.* The grade label for cheese graded as Wisconsin grade D shall consist of the words "Wisconsin grade D" on 3 separate lines, followed immediately with the grader's license number below the grade designation. The information may not be enclosed within any figure, but shall be spaced and designed so as to be legible and present a symmetrical appearance.

Note: The following is an illustration of the grade mark requirements under s. ATCP 81.22 (2) (d).

Wisconsin
Grade
D
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(e) *Undergrade*. The grade label for cheese graded as Undergrade shall consist of the word "Undergrade" followed with the grader's license number immediately below. The information may not be enclosed within any figure, but shall be spaced and designed so as to be legible and present a symmetrical appearance.

Note: The following is an illustration of the grade mark requirements under s. ATCP 81.22 (2) (e).

Undergrade

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(f) *Not graded*. All cheese which has not been graded under this chapter shall be plainly designated with the words "Not Graded" in prominent or conspicuous type size. The designation shall be applied to the cheese, the cheese wrapper or container, or to a tag attached to the container. The designation shall be affixed at the manufacturing location or at the location where the cheese is first delivered in this state, prior to further sale or shipment. The "Not Graded" designation may not be used as an alternate grade determination if grade correction is necessary.

History: Cr. Register, April, 1993, No. 448, eff. 5-1-93; am. (1) (b) and (2) (a), r. (1) (c), renun. (1) (d) to (h) to be (1) (c) to (g), Register, January, 1996, No. 481, eff. 2-1-96; CR 99-151: am. (1), Register July 2001, No. 547 eff. 8-1-01.

ATCP 81.23 Cheese grading. (1) GENERAL. Any cheese represented to be of one of the grades under s. ATCP 81.22 (1) shall conform to the standards and characteristics for the labeled grade, and shall be graded by a licensed grader or by the department. After the grade is determined, a grade mark or label under s. ATCP 81.22 (2) shall be affixed to the cheese, to the cheese wrapper or container, or to a tag attached to the container before the cheese enters wholesale channels of distribution.

(2) MOISTURE AND MILKFAT CONTENT. The moisture and milkfat content requirements of each variety of cheese for which grade standards are set forth in this chapter shall comply with the standards of identity for the cheese variety under s. 97.09 (1), Stats.

(3) STATE GRADE CERTIFICATION. All cheese graded as Wisconsin certified premium grade AA shall have the grade certified by a department grader. No person may use the Wisconsin certified premium grade AA label on cheese which has not been certified by the department. The department may also certify, upon request, a cheese grade other than Wisconsin certified premium grade AA. The department shall charge a fee to cover its cost to perform a grade certification under this subsection, regardless of whether the certification is mandatory or voluntary. Cheese which develops any objectionable defect after department grade certification shall be regraded by a licensed cheese grader. Appropriate changes shall be made in the grade labeling before further distribution or sale of the cheese.

(4) MINIMUM AGE OF CHEESE FOR STATE GRADE CERTIFICATION. All cheese except Swiss or emmentaler cheese offered for grade certification under sub. (3) shall be at least 10 days old on the date of certification. Swiss or emmentaler cheese shall be at least 60 days old on the date of certification. Age shall be determined from the date of manufacture.

(5) GRADING PROCEDURE; GENERAL. (a) To grade cheese from any vat lot, a grader shall withdraw and evaluate at least one plug from a cheese sample selected at random from that vat lot. The grader shall withdraw each plug with a cheese trier that complies with par. (b).

(b) A cheese trier shall comply with the following requirements, as applicable:

1. A cheese trier used to draw a cheese plug for the purpose of grading any cheese variety other than barrel cheese shall be constructed with a 6 inch barrel. The trier shall be tapered from a 13/16 inch diameter at the large end to a 10/16 inch diameter on the small end. The cutting depth of the barrel shall be 1/4 inch at the small end and 3/8 inch at the large end.

2. A cheese trier used to draw a plug of barrel cheese for the purpose of grading shall have a barrel which is not less than 9 inches in length. A trier for barrel cheese shall be tapered from a

15/16 inch diameter at the large end to a 11/16 inch diameter at the small end. The cutting depth of the barrel shall be 1/2 inch at the large end tapered to 5/16 inch at the small end.

3. A cheese trier used to draw a plug for grading conventional sizes of brick and muenster cheese shall be constructed with a 5 inch long barrel tapered from a diameter of 5/8 inch at the large end to a diameter of 15/32 inch on the small end. The cutting depth of the barrel shall be 7/32 inch at the small end and 5/16 inch at the large end.

(5m) SWISS CHEESE GRADING PROCEDURE. To grade Swiss or emmentaler cheese from any vat lot, a grader shall use the following procedure in place of the procedure under sub. (5):

(a) The grader shall determine flavor and body characteristics by withdrawing and evaluating at least one plug from a cheese sample selected at random from the vat lot. The grader shall withdraw the plug with a trier, inserting the trier at the approximate center of the largest flat surface area on the cheese sample. The grader shall withdraw and evaluate a full trier plug of cheese, except that a grader may withdraw and evaluate a less-than-full trier plug if the cheese is not deep enough to permit withdrawal of a full trier plug.

(b) Except as provided in par. (c) or (d), a grader shall determine texture, color and eye characteristics by evaluating a cheese wheel or block selected at random from the vat lot. The grader shall divide the cheese wheel or block approximately in half, and shall evaluate the 2 exposed cut surfaces.

(c) If cheese from a vat lot has been cut into sizes smaller than a wheel or block, a grader may determine texture, color and eye characteristics by evaluating already exposed cut surfaces without making additional cuts.

(d) At the request of the cheese owner, a grader may determine the texture, color and eye characteristics of a vat lot by withdrawing and evaluating at least one plug of cheese selected at random from that vat lot, rather than by evaluating cut surfaces under par. (b) or (c). The grader shall withdraw and evaluate the plug according to par. (a). The grader shall disclose, on the grade certification or inspection report, that the grader used this grading. The authorized representative of a cheese owner may request this grading method on behalf of the cheese owner.

(6) REGRADING. Cheese which has developed any objectionable flavor or other defect after grading shall be regraded. Original grade labels shall be removed and correct grade labels applied. When cheese is regraded, the "Not graded" designation may not be used as an alternative to the actual regraded designation.

(7) APPEALING GRADE CHANGES. A licensed cheese grader may appeal a grade change ordered by a department cheese grader. The petition may consist of a request for review by a department grading specialist of the original grade determination. The cost of the grade determination review shall be charged to the petitioner. Any party affected by a grade certification may also appeal to the department as provided in s. 93.11 (4) and (5), Stats. The appeal shall be requested in writing and shall be made not later than 10 days following the date of delivery of the cheese to the purchaser.

(8) ARBITRATION. If disagreement occurs between a producer and a buyer as to the grade of cheese, the disagreement may be resolved by arbitration. The cheese may not be moved or further processed pending arbitration. Either party to the transaction may request appointment of a grade arbitration committee. The committee shall consist of 3 arbitrators, selected from a list of licensed graders compiled by the department. Each party shall appoint one arbitrator and the 2 arbitrators initially selected shall appoint a third. The decision of the arbitration committee on the grade of the cheese shall bind the parties. The party who requests arbitration shall pay the costs of arbitration.

History: Cr. Register, April, 1993, No. 448, eff. 5-1-93; am. (4), Register, January, 1996, No. 481, eff. 2-1-96; CR 01-057: r. and recr. (5) (a), renun. (5) (b) to (d) to be (5) (b) 1 to 3., cr. (5) (b) (intro.) and (5m), Register June 2002 No. 558, eff. 7-1-02.

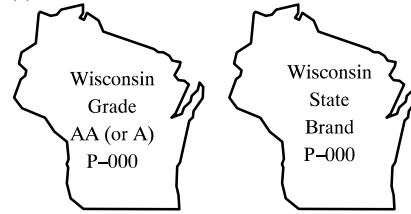
ATCP 81.24 Cheese grade labeling of retail packages. (1) **GENERAL.** A retail food establishment licensed under s. 97.30, Stats., or a food processing plant licensed under s. 97.29, Stats., may obtain a cheese grade labeling permit from the department. A permit holder may affix a cheese grade label to retail packages of graded cheese purchased in bulk by the permit holder if the bulk lot has been graded as Wisconsin Certified Premium Grade AA, Wisconsin Grade A or Wisconsin State Brand and the cheese is cut, packaged and labeled for retail distribution. No retail food establishment may grade label retail packages of cheese without a permit from the department. Retail grade labeling shall comply with this section. A dairy plant licensed under s. 97.20, Stats., may cut, wrap and grade label cheese for retail distribution if the cheese is graded by a cheese grader licensed under s. 97.175, Stats., and the retail packages are grade labeled as required under s. ATCP 81.22.

(2) **BULK GRADE DETERMINATION.** Retail packages of cheese grade labeled under sub.(1) shall consist of cut and packaged cheese which has been graded under this chapter in a bulk unit. The bulk unit of graded cheese shall bear a grade label applied by a licensed grader or department employee authorized to grade cheese. The bulk unit of graded cheese shall be re-examined by a licensed grader prior to being cut, packaged and labeled.

(3) **RETAIL PACKAGE GRADE LABELING.** The department shall issue a permit identification number to each grade labeling permit holder under sub. (1). The identification number shall consist of the letter prefix "P", followed by a three digit identification number. When affixing a grade label to retail packages of graded cheese under this section, the permit holder shall print the specified grade and the permit holder's identification number within a miniature outline map of the boundaries of the state of Wisconsin. The type shall be designed and spaced so as to be legible and present a symmetrical appearance.

Note: The following are illustrations of the grade mark requirements under s.

ATCP 81.24 (3).



History: Cr. Register, April, 1993, No. 448, eff. 5-1-93; am. (1), Register, January, 1996, No. 481, eff. 2-1-96; CR 99-151: am. (1) and (3), Register July 2001, No. 547 eff. 8-1-01.

ATCP 81.25 Recordkeeping. (1) **CONTENT.** Licensed cheese graders shall maintain records showing all of the following:

- (a) The name of the person for whom the cheese is graded.
- (b) The quantity or amount of cheese graded.
- (c) The date of grading.
- (d) The grade of the cheese as determined by the cheese grader for each lot of cheese.
- (e) The information required under s. ATCP 81.20 (1) to (5).

(2) **RECORD RETENTION.** Records required under this section shall be retained by the grader for a period of 2 years and are subject to inspection by the department upon request.

History: Cr. Register, April, 1993, No. 448, eff. 5-1-93; CR 99-151: cr. (1) (e), Register July 2001, No. 547 eff. 8-1-01.

Subchapter III —Cheese Styles, Boxes and Hoops

ATCP 81.30 Cheese styles. (1) **TRADITIONAL STYLES.** Cheese may be manufactured and sold in the traditional styles set forth in sub. (2).

(2) **STANDARDS.** Each of the following cheese styles shall conform to the weight and size standards for that style as indicated in the following chart.

| Style | Weight in Pounds | Diameter in Inches | Height in Inches | Length in Inches | Width in Inches |
|----------------------|--|--------------------------------|--|--------------------------------------|--------------------------------------|
| (1) Cheddar | 70 to 78 | 14 ¹ / ₂ | 12 to 12 ¹ / ₄ | | |
| (2) Flat | 32 to 37 | 14 ¹ / ₂ | 6 ¹ / ₈ to 6 ¹ / ₄ | | |
| (3) Daisy | 21 to 24 | 14 | 4 to 4 ¹ / ₄ | | |
| (4) Longhorn | 12 ¹ / ₂ to 13 ³ / ₄ | 6 | 12 to 12 ¹ / ₂ | | |
| (5) Midget | 11 to 12 ¹ / ₂ | 9 ³ / ₄ | 4 ¹ / ₄ to 4 ³ / ₈ | | |
| (6) 20-lb. block | 20 ¹ / ₄ to 22 | | 3 ¹ / ₈ to 3 ⁵ / ₈ | 14 to 14 ¹ / ₄ | 11 to 11 ¹ / ₄ |
| (7) 40-lb. block | 41 to 44 | | 6 ⁷ / ₈ to 7 ³ / ₄ | 14 to 14 ¹ / ₄ | 11 to 11 ¹ / ₄ |
| (8) 60-lb. block | 61 to 65 | | 10 ³ / ₈ to 10 ⁵ / ₈ | 14 to 14 ¹ / ₄ | 11 to 11 ¹ / ₄ |
| (9) 640-lb. block | 640 (min.) | | | | |
| (10) Barrel; 55 gal. | | | | | |
| (a) Metal | 480 (min.) | 22 ¹ / ₂ | 33 ¹ / ₂ | | |
| (b) Fiber | 480 (min.) | 23 ¹ / ₂ | 33 to 34 | | |

History: Cr. Register, April, 1993, No. 448, eff. 5-1-93; CR 99-151: am. (2) (chart), Register July 2001, No. 547 eff. 8-1-01.

ATCP 81.31 Cheese container requirements.

(1) **CHEESE HOOPS.** Cheese hoops shall be of the correct size and shape, so that cheese which is molded in the hoop conforms to the weight and size standards specified under s. ATCP 81.30 (2).

(2) **NEW CHEESE BOXES.** All cheese boxes or containers shall be securely nailed or bound together so that they are strong enough to carry the weight of the cheese the box or container is designed to carry. Cheese boxes and containers shall conform to all of the following requirements:

(a) The dimensions of the box or container shall be adequate to enable easy entry and removal of the cheese while conforming the finished product to the weight and size standards of s. ATCP 81.30 (2). The container shall thoroughly envelop and protect the cheese.

(b) All cheese boxes shall be clean and free of insects or other forms of contamination prior to sale or use.

(c) Boxes manufactured from wood or veneer shall be constructed of commercially dry materials and contain not more than 18% moisture prior to sale or use as a receptacle for cheese.

(d) Scale boards may not contain in excess of 18% moisture.

(e) The name and address of the manufacturer shall be plainly stamped, impressed or labeled in type at least 1/4 inch high on the body of all boxes or containers manufactured for use as a receptacle or container for cheese.

(3) **USED CHEESE BOXES.** (a) Before being reused as cheese containers, all previously used boxes shall be reconditioned as necessary, and shall be thoroughly cleaned. Reused boxes shall be free from adhering material, objectionable odors, mold, or other unsanitary conditions.

(b) Used wood or veneer boxes shall meet the moisture requirements of new boxes under sub. (2) (c) at the time of reuse.

(c) Before a cheese box is reused to contain cheese, all mark-

ings other than the designation of the original manufacturer shall be completely obliterated or removed from the box.

(4) **BARRELS.** Barrels used for marketing or transporting barrel cheese shall be free of liquids or excess moisture, and shall be covered with full, removable covers which are securely jacketed and sealed.

(5) **OTHER BOXES OR CONTAINERS.** (a) The department may authorize the temporary experimental use of a new type of box or container which deviates from the requirements or standards under this section, to determine whether it is suitable for use in containing or shipping of cheese. If a new experimental container is found to be satisfactory, the department may authorize its continued or general use. Department approval may be withdrawn if an experimental box or container is found to be unsatisfactory.

(b) If shipping materials or containers conform to standards adopted by the United States department of agriculture for the marketing and transporting of cheese, those materials or containers are also deemed to comply with this section.

History: Cr. Register, April, 1993, No. 448, eff. 5-1-93; am. (2) (e), Register, January, 1996, No. 481, eff. 2-1-96.

Subchapter IV — Cheddar, Granular and Washed Curd Cheese; Grade Standards

ATCP 81.40 Wisconsin certified premium grade AA standards. Cheddar, granular and washed curd cheese labeled or sold as Wisconsin certified premium grade AA shall conform to the following standards:

(1) **FLAVOR CHARACTERISTICS.** The flavor of Wisconsin certified premium grade AA cheddar, granular and washed curd cheese shall be fine, highly pleasing and free from undesirable flavors and odors. The cheese may possess very slight feed flavors. Flavor standards are shown in the grade AA column of Table 1. The presence or absence of flavor characteristics in Table 1 shall be determined organoleptically by taste and smell.

TABLE 1. CHEDDAR, GRANULAR AND WASHED CURD CHEESE

| GRADING STANDARDS FOR FLAVOR CHARACTERISTICS | | | | | | | | | |
|---|------------------|--------------|---------------|---------------------------|--------------|---------------|------------------|--------------|---------------|
| IDENTIFIED FLAVOR CHARACTERISTIC IN CHEESE BEING GRADED | AA | | | A (Wisconsin State Brand) | | | B | | |
| | Fresh or Current | Medium Cured | Cured or Aged | Fresh or Current | Medium Cured | Cured or Aged | Fresh or Current | Medium Cured | Cured or Aged |
| FEED | VS | VS | VS | S | S | S | D | D | D |
| ACID | | | | VS | S | S | S | D | D |
| FLAT | | | | | | | S | S | S |
| BITTER | | | | | VS | S | S | D | D |
| FRUITY | | | | | | | S | D | D |
| UTENSIL | | | | | | | S | D | D |
| METALLIC | | | | | | | | | |
| SOUR | | | | | | | | | |
| WHEY-TAINT | | | | | | | S | D | D |
| YEASTY | | | | | | | S | S | S |
| MALTY | | | | | | | S | S | S |
| OLD MILK | | | | | | | S | S | S |
| WEEDY | | | | | | | S | S | S |
| ONION | | | | | | | VS | VS | VS |
| BARNY | | | | | | | S | S | S |
| LIPASE OR RANCID | | | | | | | VS | S | S |
| SULFIDE | | | | | | | | | S |

VS = very slight; S = slight; D = definite; P = pronounced; Blank = none

(2) Body and texture characteristics. The body and texture of Wisconsin certified premium grade AA cheddar, granular and washed curd cheese shall be firm and solid, smooth, compact and close. The cheese may possess a few small mechanical openings to a very slight degree and shall appear translucent. The texture of

granular cheese may be solid, compact and close, or alternatively, it may be medium open with numerous small mechanical openings distributed throughout the cheese. Body and texture standards are shown in the grade AA column of Table 2.

TABLE 2. CHEDDAR, GRANULAR AND WASHED CURD CHEESE

| GRADING STANDARDS FOR BODY AND TEXTURE CHARACTERISTICS | | | | | | | | | |
|---|------------------|--------------|---------------|---------------------------|--------------|---------------|------------------|--------------|---------------|
| IDENTIFIED BODY AND TEXTURE CHARACTERISTIC IN CHEESE BEING GRADED | AA | | | A (Wisconsin State Brand) | | | B | | |
| | Fresh or Current | Medium Cured | Cured or Aged | Fresh or Current | Medium Cured | Cured or Aged | Fresh or Current | Medium Cured | Cured or Aged |
| CURDY | S | VS | | D | S | | D | S | |
| COARSE | | | | | | | S | S | |
| OPEN | VS | S | S | S | S | S | D | D | D |
| SWEET HOLES | | | | | | | D | D | D |
| SHORT | | | | | S | S | S | D | D |
| MEALY | | | | | S | S | S | D | D |
| WEAK | | | | | S | S | S | D | D |
| PASTY | | | | | | VS | S | D | D |
| CRUMBLY | | | | | | S | S | D | D |
| GASSY | | | | | | | S | S | S |
| SLITTY | | | | | | | S | S | S |
| CORKY | | | | | | | S | S | |
| PINNY | | | | | | | | | |

VS = very slight; S = slight; D = definite; P = pronounced; Blank = condition not present.

(3) COLOR CHARACTERISTICS. Wisconsin certified premium grade AA cheddar, granular and washed curd cheese may be uncolored or colored to any degree recognized in the cheese industry.

The color shall be uniform and not dull or faded. The cheese may possess numerous tiny white specks associated with aged cheese. Color standards are shown in the grade AA column of Table 3.

TABLE 3. CHEDDAR, GRANULAR AND WASHED CURD CHEESE

| GRADING STANDARDS FOR COLOR CHARACTERISTICS | | | | | | | | | |
|--|------------------|--------------|---------------|---------------------------|--------------|---------------|------------------|--------------|---------------|
| IDENTIFIED COLOR CHARACTERISTIC IN CHEESE BEING GRADED | AA | | | A (Wisconsin State Brand) | | | B | | |
| | Fresh or Current | Medium Cured | Cured or Aged | Fresh or Current | Medium Cured | Cured or Aged | Fresh or Current | Medium Cured | Cured or Aged |
| SEAMY | | VS | VS | S | S | S | D | D | D |
| WAVY | | | | VS | | | S | S | S |
| ACID CUT | | | | | | | S | S | S |
| UNNATURAL | | | | | | | S | S | S |
| MOTTLED | | | | | | | S | S | S |
| SALT SPOTS | | | | | | | S | S | S |
| DULL or FADED | | | | | | | S | S | S |
| BLEACHED SURFACE (rindless) | | | | | | | | VS | S |

VS = very slight; S = slight; D = definite; P = pronounced; Blank = condition not present.

(4) FINISH AND APPEARANCE CHARACTERISTICS. Wisconsin certified premium grade AA cheddar, granular and washed curd cheese shall have the following finish and appearance characteristics:

(a) *Bandaged and paraffin-dipped cheese.* The rind shall be sound, firm and smooth, providing good protection to the cheese. The bandage shall be evenly placed on the ends of the cheese, shall be free from unnecessary overlapping and wrinkles, and shall not

be burst or torn. The cheese surface shall have a good coating of paraffin or wax that adheres firmly to all surfaces of the cheese. A slight amount of mold may be present under the bandage and paraffin within reasonable limited tolerances for the degree of curing, with no indication that mold has entered the cheese. The exterior appearance of the cheese shall be free from high edges, huffing and lopsidedness. Finish and appearance standards are shown in the grade AA column of Table 4.

TABLE 4. CHEDDAR, GRANULAR AND WASHED CURD CHEESE

| GRADING STANDARDS FOR FINISH AND APPEARANCE CHARACTERISTICS | | | | | | | | | |
|--|------------------|--------------|---------------|---------------------------|--------------|---------------|------------------|--------------|---------------|
| IDENTIFIED FINISH AND APPEARANCE CHARACTERISTIC IN CHEESE BEING GRADED | AA | | | A (Wisconsin State Brand) | | | B | | |
| | Fresh or Current | Medium Cured | Cured or Aged | Fresh or Current | Medium Cured | Cured or Aged | Fresh or Current | Medium Cured | Cured or Aged |
| SOILED SURFACE | VS | S | S | VS | S | S | S | D | D |
| SURFACE MOLD | | S | D | VS | S | D | S | S | D |
| MOLD UNDER BANDAGE and PARAFFIN | | VS | S | | VS | S | VS | S | D |
| MOLD UNDER WRAPPER or COVERING | | VS | VS | | VS | VS | | S | S |
| ROUGH SURFACE | | | | S | S | S | D | D | D |
| IRREGULAR BANDAGING (uneven, wrinkled and overlapping) | | | | S | S | S | D | D | D |
| LOPSIDED | | | | S | S | S | D | D | D |
| LOPSIDED (rindless) | | | | S | S | S | S | S | S |
| HIGH EDGES | | | | S | S | S | D | D | D |
| HUFFED | | | | | | | S | S | S |
| DEFECTIVE COATING (scaly, blistered & checked) | | | | | | | | | |
| CRACKS IN RIND | | | | | | | | | |
| CHECKED RIND | | | | | | | S | S | S |
| SOFT SPOTS | | | | | | | | | |
| WEAK RIND | | | | | | | S | S | S |
| SOUR RIND | | | | | | | S | S | S |

| GRADING STANDARDS FOR FINISH AND APPEARANCE CHARACTERISTICS (Continued) | | | | | | | | | |
|---|------------------|--------------|---------------|---------------------------|--------------|---------------|------------------|--------------|---------------|
| IDENTIFIED FINISH AND APPEARANCE CHARACTERISTIC IN CHEESE BEING GRADED | AA | | | A (Wisconsin State Brand) | | | B | | |
| | Fresh or Current | Medium Cured | Cured or Aged | Fresh or Current | Medium Cured | Cured or Aged | Fresh or Current | Medium Cured | Cured or Aged |
| WET RIND | | | | | | | | | |
| RIND ROT | | | | | | | | | |

VS = very slight; S = slight; D = definite; P = pronounced; Blank = condition not present.

(b) *Rindless*. The wrapper or covering of rindless cheese graded as AA shall adequately and securely envelop the cheese, shall be unbroken, and shall fully protect the surface. The wrapper or covering may be slightly wrinkled. The cheese shall be free from huffing and lopsidedness. It may have very slight mold under the wrapper or covering in the medium cured and cured classifications, with no indication that mold has entered the cheese. Finish and appearance standards are shown in the grade AA column of Table 4 under par. (a).

History: Cr. Register, April, 1993, No. 448, eff. 5-1-93.

ATCP 81.41 Wisconsin grade A or Wisconsin state brand standards. Cheddar, granular and washed curd cheese labeled or sold as Wisconsin grade A or Wisconsin state brand shall conform to the following standards:

(1) **FLAVOR CHARACTERISTICS.** The flavor of Wisconsin grade A and Wisconsin state brand cheddar, granular and washed curd cheese shall be pleasing and free from undesirable flavors and odors. The cheese may possess a feed, acid and bitter flavor with limited tolerances as the cheese ages. Flavor standards are shown in the grade A column of Table 1 under s. ATCP 81.40 (1). The presence or absence of flavor characteristics shall be determined organoleptically by taste and smell.

(2) **BODY AND TEXTURE CHARACTERISTICS.** The body and texture of Wisconsin grade A and Wisconsin state brand cheddar, granular and washed curd cheese shall be reasonably solid, compact, and close. The cheese shall appear translucent and may have a few mechanical openings but the openings may not be large and connected to other openings. Body and texture standards are shown in the grade A column of Table 2 under s. ATCP 81.40 (2).

(3) **COLOR CHARACTERISTICS.** Wisconsin grade A and Wisconsin state brand cheddar, granular and washed curd cheese may be colored or uncolored. The color shall be uniform and not dull or faded. The cheese may possess numerous tiny white specks associated with aged cheese, and may also possess seaminess and waviness to a slight degree. Color standards are shown in the grade A column of Table 3 under s. ATCP 81.40 (3).

(4) **FINISH AND APPEARANCE CHARACTERISTICS.** Wisconsin grade A and Wisconsin state brand cheddar, granular and washed curd cheese shall have the following finish and appearance characteristics:

(a) *Bandaged and paraffin dipped cheese.* The rind shall be sound, firm and smooth, and provide good protection to the cheese. The bandage may be slightly uneven, overlapped or wrinkled, but shall not be burst or torn. The surface shall be practically smooth and bright and have a good coating of paraffin or wax that adheres firmly to all surfaces of the cheese. Mold and other defects shall be within allowable tolerances for the grade according to the degree of curing, with no indication that mold has entered the cheese. The exterior shall be free from huffing, but may have slightly high edges and be slightly lopsided. Finish and appearance standards are shown in the grade A column of Table 4 under s. ATCP 81.40 (4) (a).

(b) *Rindless.* The wrapper or covering of rindless cheese graded as Wisconsin grade A or Wisconsin state brand shall adequately and securely envelop the cheese, be unbroken and fully

protect the surface, but may be slightly wrinkled. The cheese shall be free from huffing but may be slightly lopsided and may have very slight mold under the wrapper or covering in the medium cured and cured classifications, with no indication that mold has entered the cheese. Finish and appearance standards are shown in the grade A column of Table 4 under s. ATCP 81.40 (4) (a).

History: Cr. Register, April, 1993, No. 448, eff. 5-1-93.

ATCP 81.42 Wisconsin grade B standards. Cheddar, granular and washed curd cheese labeled or sold as Wisconsin grade B cheese shall conform to the following standards.

(1) **FLAVOR CHARACTERISTICS.** Wisconsin grade B cheddar, granular and washed curd cheese shall be characterized by a fairly pleasing cheese flavor. The cheese may also possess certain undesirable flavors to a limited degree based on the aged or cured condition of the cheese. Flavor standards are shown in the grade B column of Table 1 under s. ATCP 81.40 (1). The presence or absence of flavor characteristics shall be determined organoleptically by taste and smell.

(2) **BODY AND TEXTURE CHARACTERISTICS.** The body and texture of Wisconsin grade B cheddar, granular and washed curd cheese may be loose and open, and may have numerous sweet holes, scattered yeast holes, and other scattered gas holes. The cheese may possess other body and texture characteristics to various degrees depending on the aged or cured status of the sample being graded. Body and texture standards are shown in the grade B column of Table 2 under s. ATCP 81.40 (2).

(3) **COLOR CHARACTERISTICS.** Wisconsin grade B cheddar, granular and washed curd cheese may be uncolored or colored. Color standards are shown in the grade B column of Table 3 under s. ATCP 81.40 (3).

(4) **FINISH AND APPEARANCE CHARACTERISTICS.** Wisconsin grade B cheddar, granular and washed curd cheese shall have the following finish and appearance characteristics:

(a) *Bandaged and paraffin dipped.* The rind for Wisconsin grade B cheddar, granular and washed curd cheese shall be sound. It may be slightly weak, but shall be free from soft spots, rind rot, cracks and openings of any kind. The bandage may be uneven and wrinkled but shall not be burst or torn. The surface may be rough and unattractive but shall possess a fairly good coating of paraffin or wax. The paraffin may be scaly or blistered. Mold and other various characteristics may be present to the permitted degree based on the aged or cured status of the cheese, but there shall be no indication that mold has entered the cheese. The exterior may be huffed, lopsided and have high edges. Finish and appearance standards are shown in the grade B column of Table 4 under s. ATCP 81.40 (4) (a).

(b) *Rindless.* The covering or wrapper of rindless cheese graded as Wisconsin grade B shall be fairly neat, and shall adequately and securely envelop the cheese to protect the surface. The wrapper may not be broken but may be wrinkled. The cheese may be huffed and lopsided. The cheese may have slight mold under the wrapper or covering in the medium cured and cured classifications, but there shall be no indication that mold has

entered the cheese. Finish and appearance standards are shown in the grade B column of Table 4 under s. ATCP 81.40 (4) (a).

History: Cr. Register, April, 1993, No. 448, eff. 5-1-93.

Subchapter V —Colby and Monterey (Jack) Cheese; Grade Standards

ATCP 81.50 Wisconsin certified premium grade AA standards. Colby and monterey (jack) cheese labeled or sold as Wisconsin certified premium grade AA shall conform to the following standards:

(1) **FLAVOR CHARACTERISTICS.** Wisconsin certified premium grade AA colby and monterey (jack) cheese may be lacking in flavor development, or may possess characteristic cheese flavors. The flavor shall be fine, highly pleasing and free from undesirable flavors and odors, except it may possess a very slight feed flavor. Flavor standards are shown in the grade AA column of Table 5. The presence or absence of flavor characteristics shall be determined organoleptically by taste and smell.

TABLE 5. COLBY AND MONTEREY (JACK) CHEESE

| GRADING STANDARDS FOR FLAVOR CHARACTERISTICS | | | |
|---|----|---------------------------|----|
| IDENTIFIED FLAVOR CHARACTERISTIC IN CHEESE BEING GRADED | AA | A (Wisconsin State Brand) | B |
| FEED | VS | S | D |
| ACID | | | VS |
| FLAT | | | S |
| BITTER | | VS | S |
| FRUITY | | | S |
| UTENSIL | | | S |
| SOUR | | | VS |
| WHEY-TAINT | | | S |
| YEASTY | | | S |
| MALTY | | | S |
| OLD MILK | | | S |
| WEEDY | | | S |
| ONION | | | VS |
| BARNY | | | S |
| LIPASE or RANCID | | | VS |

VS = very slight; S = slight; D = definite; P = pronounced; Blank = none detectable.

(2) **BODY AND TEXTURE CHARACTERISTICS.** Wisconsin certified premium grade AA colby and monterey (jack) cheese shall be reasonably firm. The cheese may have evenly distributed small mechanical openings or a closed body. The cheese may not contain any sweet holes, yeast holes or other gas holes. The cheese may be definitely curdy or partially broken down if it is more than 3 weeks old. Body and texture standards are shown in the grade AA column of Table 6.

TABLE 6. COLBY AND MONTEREY (JACK) CHEESE

| GRADING STANDARDS FOR BODY AND TEXTURE CHARACTERISTICS | | | |
|---|----------|---------------------------------|---------|
| IDENTIFIED BODY AND TEXTURE CHARACTERISTIC IN CHEESE BEING GRADED | GRADE AA | GRADE A (Wisconsin State Brand) | GRADE B |
| CURDY | | D | D |
| COARSE | | | S |
| SWEET HOLES | | | S |
| SHORT | | | S |
| MEALY | | | S |
| WEAK | | | S |
| PASTY | | | S |
| CRUMBLY | | | S |
| GASSY | | | S |
| SLITTY | | | S |
| CORKY | | | S |

VS = very slight; S = slight; D = definite; P =pronounced; Blank = condition not present.

(3) **COLOR CHARACTERISTICS.** (a) Wisconsin certified premium grade AA colby cheese may be uncolored or colored to any degree recognized within the cheese manufacturing industry. The color shall be uniform, bright and attractive.

(b) Wisconsin certified premium grade AA monterey (jack) cheese may not be colored.

(c) Color standards for Wisconsin certified premium grade AA colby and monterey (jack) cheese are shown in the grade AA column of Table 7.

TABLE 7. COLBY AND MONTEREY (JACK) CHEESE

| GRADING STANDARDS FOR COLOR CHARACTERISTICS | | | |
|--|----------|---------------------------------|---------|
| IDENTIFIED COLOR CHARACTERISTIC IN CHEESE BEING GRADED | GRADE AA | GRADE A (Wisconsin State Brand) | GRADE B |
| WAVY | | VS | S |
| ACID-CUT | | | S |
| UNNATURAL | | | S |
| MOTTLED | | | S |
| SALT SPOTS | | | S |
| DULL OR FADED | | | S |
| BLEACHED SURFACE (rindless) | | | S |

VS = very slight; S = slight; D = definite; P =pronounced; Blank = condition not present.

(4) **FINISH AND APPEARANCE CHARACTERISTICS.** Wisconsin certified premium grade AA colby and monterey (jack) cheese shall have the following finish and appearance characteristics:

(a) *Bandaged and paraffin dipped.* The rind shall be sound, firm, and smooth, and shall provide good protection to the cheese. The bandage shall be evenly placed on the end and over the entire surface of the cheese, shall be free from unnecessary overlapping and wrinkles, and shall not be burst or torn. The cheese surface shall be smooth and bright and shall have a good coating of paraffin or wax that adheres firmly to the entire surface of the cheese. The cheese shall be free from mold under the bandage and paraffin. It shall also be free from high edges, huffing and lopsidedness,

but may possess a soiled surface to a very slight degree. Finish and appearance standards are shown in the grade AA column of Table 8.

TABLE 8. COLBY AND MONTEREY (JACK) CHEESE

| GRADING STANDARDS FOR FINISH AND APPEARANCE CHARACTERISTICS | | | |
|--|----------|---------------------------------|---------|
| IDENTIFIED FINISH AND APPEARANCE CHARACTERISTIC IN CHEESE BEING GRADED | GRADE AA | GRADE A (Wisconsin State Brand) | GRADE B |
| SOILED SURFACE | | VS | S |
| SURFACE MOLD | | VS | S |
| MOLD UNDER BANDAGE and PARAFFIN | | | VS |
| MOLD UNDER WRAPPER or COVERING (rindless) | | | VS |
| ROUGH SURFACE | | S | D |
| IRREGULAR BANDAGING (uneven wrinkled and overlapping) | | S | D |
| LOPSIDED | | S | D |
| LOPSIDED (rindless) | | S | S |
| HIGH EDGES | | S | D |
| DEFECTIVE COATING (scaly, blistered and checked) | | | S |
| CHECKED RIND | | | S |
| WEAK RIND | | | S |
| SOUR RIND | | | S |
| WRINKLED WRAPPER or COVERING (rindless) | | S | D |

VS = very slight; S = slight; D = definite; P = pronounced; Blank = condition not present.

(b) *Rindless*. The wrapper or covering of rindless cheese graded as grade AA shall be practically smooth. The wrapper or covering shall be properly sealed with adequate overlapping at the seams, or by a suitable alternative closure. The wrapper or covering shall be neat, and shall adequately and securely envelop the cheese, but may be slightly wrinkled. Allowance may be made for wrinkles caused by crimping or sealing when vacuum packaging is used. The cheese shall be free from mold under the wrapper or covering and shall not be huffed or lopsided. Finish and appearance standards are shown in the grade AA column of Table 8 under par. (a).

History: Cr. Register, April, 1993, No. 448, eff. 5-1-93; emerg. am. (2), eff. 8-8-98; am. (2), Register, May, 1999, No. 521, eff. 6-1-99.

ATCP 81.51 Wisconsin grade A or Wisconsin state brand standards. Colby and monterey (jack) cheese labeled or sold as Wisconsin grade A or Wisconsin state brand shall conform to the following standards:

(1) **FLAVOR CHARACTERISTICS.** Wisconsin grade A and Wisconsin state brand colby and monterey (jack) cheese may be lacking in flavor development or possess a slight characteristic cheese flavor which is pleasing and free from undesirable flavors and odors, except that the cheese may possess a very slight bitter flavor and slight acid or feed flavors. Flavor standards are shown in the grade A column of Table 5 under s. ATCP 81.50 (1). The presence or absence of flavor characteristics shall be determined organoleptically by taste and smell.

(2) **BODY AND TEXTURE CHARACTERISTICS.** Wisconsin grade A and Wisconsin state brand colby and monterey (jack) cheese shall be reasonably firm. The cheese may have evenly distributed

mechanical openings or a closed body. When present, mechanical openings may not be large or connected to other openings. The cheese shall be free from sweet holes, yeast holes, or other gas holes. The cheese shall be definitely curdy or partially broken down if it is more than 3 weeks old. Body and texture standards are shown in the grade A column of Table 6 under s. ATCP 81.50 (2).

(3) **COLOR CHARACTERISTICS.** Wisconsin grade A or Wisconsin state brand colby or monterey (jack) cheese shall have a fairly uniform, bright attractive appearance. Colby cheese may either be colored or uncolored but the coloration shall be uniform with very slight waviness permitted. Color standards are shown in the grade A column of Table 7 under s. ATCP 81.50 (3).

(4) **FINISH AND APPEARANCE CHARACTERISTICS.** Wisconsin grade A and Wisconsin state brand colby and monterey (jack) cheese shall have the following finish and appearance characteristics:

(a) *Bandaged and paraffin dipped*. The rind shall be sound, firm, and smooth, and shall provide good protection to the cheese. The bandage may be slightly uneven, overlapped or wrinkled but shall not be burst or torn. The surface shall be practically smooth and bright and shall have a good coating of paraffin or wax that adheres firmly to all surfaces of the cheese. The cheese shall be free from mold under the bandage. Finish and appearance standards are shown in the grade A column of Table 8 under s. ATCP 81.50 (4) (a).

(b) *Rindless*. The wrapper or covering shall be practically smooth. The wrapper or covering shall be properly sealed with adequate overlapping at the seams, or by a suitable alternative type of closure. The wrapper or covering shall be neat and shall adequately and securely envelop the cheese. The wrapper or covering shall fully protect the surface of the cheese. The wrapper or covering may be slightly wrinkled, but may not detract from the initial quality of the cheese. The cheese shall be free from mold under the wrapper or covering, and shall not be huffed. The cheese may be slightly lopsided. Finish and appearance standards are shown in the grade A column of Table 8 under s. ATCP 81.50 (4) (a).

History: Cr. Register, April, 1993, No. 448, eff. 5-1-93; emerg. am. (2), eff. 8-8-98; am. (2), Register, May, 1999, No. 521, eff. 6-1-99.

ATCP 81.52 Wisconsin grade B standards. Colby and monterey (jack) cheese labeled or sold as Wisconsin grade B shall conform to the following standards.

(1) **FLAVOR CHARACTERISTICS.** Wisconsin grade B colby and monterey (jack) cheese shall possess a fairly pleasing characteristic cheese flavor. Flavor standards are shown in the grade B column of Table 5 under s. ATCP 81.50 (1). The presence or absence of flavor characteristics shall be determined organoleptically by taste and smell.

(2) **BODY AND TEXTURE CHARACTERISTICS.** Wisconsin grade B colby and monterey (jack) cheese may be loosely knit and open. The cheese may have mechanical openings or a closed body. There may be a limited amount of sweet holes, scattered yeast holes and other scattered gas holes, but pinny gas holes are not permitted. Body and texture standards are shown in the grade B column of Table 6 under s. ATCP 81.50 (2).

(3) **COLOR CHARACTERISTICS.** Wisconsin grade B colby and monterey (jack) cheese may possess to a slight degree each of the color characteristics shown in the grade B column of Table 7 under s. ATCP 81.50 (3). Rindless cheese varieties may also have a slight bleached surface.

(4) **FINISH AND APPEARANCE CHARACTERISTICS.** Wisconsin grade B colby and monterey (jack) cheese shall have the following finish and appearance characteristics:

(a) *Bandaged and paraffin dipped*. The rind of grade B cheese shall be reasonably sound. It may be slightly weak but shall be free from soft spots, rind rot, cracks and openings of any kind. The

bandage may be uneven and wrinkled, but shall not be burst or torn. The surface of the cheese may be rough and unattractive, but shall be entirely coated with paraffin or wax. The paraffin may be scaly or blistered, with a very slight mold under the bandage or paraffin. There shall be no indication that mold has entered the cheese. Finish and appearance standards are shown in the grade B column of Table 8 under s. ATCP 81.50 (4) (a).

(b) *Rindless*. The wrapper or covering of grade B cheese shall be unbroken but the wrapper or covering may be definitely wrinkled. The wrapper or covering shall securely envelop the cheese. Finish and appearance standards are shown in the grade B column of Table 8 under s. ATCP 81.50 (4) (a).

History: Cr. Register, April, 1993, No. 448, eff. 5-1-93; emerg. am. (2), eff. 8-8-98; am. (2), Register, May, 1999, No. 521, eff. 6-1-99.

Subchapter VI — Brick and Muenster Cheese; Grade Standards

ATCP 81.60 Wisconsin certified premium grade AA standards. Brick and muenster cheese labeled or sold as Wisconsin certified premium grade AA shall conform to the following standards:

(1) **FLAVOR CHARACTERISTICS.** Wisconsin certified premium grade AA brick and muenster cheese shall be fine, highly pleasing and free from undesirable flavors and odors, except that the cheese may have a very slight feed flavor. Flavor standards are shown in the grade AA column of Table 9. The presence or absence of flavor characteristics shall be determined organoleptically by taste and smell.

TABLE 9. BRICK AND MUENSTER CHEESE

| GRADING STANDARDS FOR FLAVOR CHARACTERISTICS | | | |
|---|----------|---------------------------------|---------|
| IDENTIFIED FLAVOR CHARACTERISTIC IN CHEESE BEING GRADED | GRADE AA | GRADE A (Wisconsin State Brand) | GRADE B |
| FEED | VS | S | D |
| ACID | | | S |
| FLAT | | VS | S |
| BITTER | | | S |
| FRUITY | | | S |
| UTENSIL | | | S |
| SOUR | | | VS |
| WHEY-TAINT | | | S |
| YEASTY | | | S |
| MALTY | | | S |
| OLD MILK | | | S |
| WEEDY | | | S |
| ONION | | | VS |
| BARNY | | | S |
| LIPASE or RANCID | | | VS |
| METALLIC | | | S |

VS = very slight; S = slight; D = definite; P = pronounced; Blank = none detectable.

(2) **BODY AND TEXTURE CHARACTERISTICS.** Wisconsin certified premium grade AA brick and muenster cheese shall have good body and texture. The cheese may be close or have even distribution of mechanical openings and shall be slightly translucent. The cheese shall also be free from sweet holes, pin holes and other gas holes. The texture may be slightly curdy or partially broken down depending on the age of the cheese. The cheese shall have a uniform distribution of salt. Body and texture standards are shown in the grade AA column of Table 10.

TABLE 10. BRICK AND MUENSTER CHEESE

| GRADING STANDARDS FOR BODY AND TEXTURE CHARACTERISTICS | | | |
|---|----------|---------------------------------|---------|
| IDENTIFIED BODY AND TEXTURE CHARACTERISTIC IN CHEESE BEING GRADED | GRADE AA | GRADE A (Wisconsin State Brand) | GRADE B |
| CURDY | | D | D |
| SWEET HOLES | | VS | S |
| SHORT | | | S |
| MEALY | | | S |
| CRUMBLY | | | S |
| CORKY | | | S |
| WEAK | | | S |
| PASTY | | | S |
| GASSY | | | S |
| PINNY | | | S |
| SLITTY | | | S |

VS = very slight; S = slight; D = definite; P = pronounced; Blank = condition not present.

(3) **COLOR CHARACTERISTICS.** Wisconsin certified premium grade AA brick and muenster cheese may be either uncolored or colored to any degree recognized within the cheese manufacturing industry. The color shall be uniform, bright and attractive. Color standards are shown in the grade AA column of Table 11.

TABLE 11. BRICK AND MUENSTER CHEESE

| GRADING STANDARDS FOR COLOR CHARACTERISTICS | | | |
|--|----------|---------------------------------|---------|
| IDENTIFIED COLOR CHARACTERISTIC IN CHEESE BEING GRADED | GRADE AA | GRADE A (Wisconsin State Brand) | GRADE B |
| UNEVEN COLOR | | | S |
| ACID-CUT | | | |

VS = very slight; S = slight; D = definite; P = pronounced; Blank = condition not present.

(4) **FINISH AND APPEARANCE CHARACTERISTICS.** Wisconsin certified premium grade AA brick and muenster cheese shall be well-shaped and uniform in size with a smooth and well closed surface. The wrapper or covering shall be practically smooth and properly sealed with adequate overlapping to securely envelop the cheese, or shall be sealed by an alternative and satisfactory type of closure. Allowance shall be made for slight wrinkles caused by crimping or sealing when vacuum packaging is used. The cheese shall be free from mold under the wrapper or covering and shall

not be misshaped or huffed. Finish and appearance standards are shown in the grade AA column of Table 12.

TABLE 12. BRICK AND MUENSTER CHEESE

| GRADING STANDARDS FOR FINISH AND APPEARANCE CHARACTERISTICS | | | |
|--|----------|---------------------------------|---------|
| IDENTIFIED FINISH AND APPEARANCE CHARACTERISTIC IN CHEESE BEING GRADED | GRADE AA | GRADE A (Wisconsin State Brand) | GRADE B |
| SURFACE DEFECTS | | VS | S |
| SURFACE MOLD | | | |
| MOLD UNDER WRAPPER OR COVERING | | | |
| ROUGH SURFACE | | VS | S |
| LOPSIDED | | | VS |
| SOFT SPOTS | | | |
| HUFFED | | | |

VS = very slight; S = slight; D = definite; P = pronounced; Blank = condition not present.

History: Cr. Register, April, 1993, No. 448, eff. 5-1-93.

ATCP 81.61 Wisconsin grade A or Wisconsin state brand standards. Brick or muenster cheese labeled or sold as Wisconsin grade A or Wisconsin state brand shall conform to the following standards:

(1) **FLAVOR CHARACTERISTICS.** Wisconsin grade A and Wisconsin state brand brick and muenster cheese shall be pleasing and free from undesirable flavors and odors. The cheese may be lacking in flavor development or may have progressive characteristic cheese flavors. The cheese may have a very slight flat flavor and a very slight feed flavor. Flavor standards are shown in the grade A column of Table 9 under s. ATCP 81.60 (1). The presence or absence of flavor characteristics shall be determined organoleptically by taste and smell.

(2) **BODY AND TEXTURE CHARACTERISTICS.** Wisconsin grade A or Wisconsin state brand brick and muenster cheese shall have a good body. The texture may be close or have even distribution of mechanical openings and very slight sweet holes but shall be free from other gas holes. The body shall be slightly translucent. The texture may be definitely curdy or partially broken down, depending on the age of the cheese. The cheese shall have a uniform distribution of salt. Body and texture standards are shown in the grade A column of Table 10 under s. ATCP 81.60 (2).

(3) **COLOR CHARACTERISTICS.** Wisconsin grade A and Wisconsin state brand brick and muenster cheese may be either uncolored or colored to any degree recognized within the cheese manufacturing industry, but the coloration which is added shall be uniform and not dull or faded. Color standards are shown in the grade A column of Table 11 under s. ATCP 81.60 (3).

(4) **FINISH AND APPEARANCE CHARACTERISTICS.** Wisconsin grade A and Wisconsin state brand brick and muenster cheese shall be well-shaped, uniform in size and free of soiled surfaces, check or mold. The surfaces shall be well closed. The wrapper or covering shall be practically smooth. The wrapper or covering shall be properly sealed with adequate overlapping to securely envelop the cheese, or shall be sealed by an alternative and satisfactory type of closure. Allowance shall be made for wrinkles caused by crimping or sealing when vacuum packaging is used. The cheese shall not be misshaped or huffed. Finish and appearance standards are shown in the grade A column of Table 12 under s. ATCP 81.60 (4).

History: Cr. Register, April, 1993, No. 448, eff. 5-1-93.

ATCP 81.62 Wisconsin grade B standards. Brick or muenster cheese labeled or sold as Wisconsin grade B cheese shall conform to the following standards:

(1) **FLAVOR CHARACTERISTICS.** Wisconsin grade B brick and muenster cheese shall possess a fairly pleasing characteristic cheese flavor. The cheese may also possess various undesirable flavors to a slight or very slight degree. Cured brick cheese may develop a surface microorganism that contributes to flavor development as the cheese ages. Flavor standards are shown in the grade B column of Table 9 under s. ATCP 81.60 (1). The presence or absence of flavor characteristics shall be determined organoleptically by taste and smell.

(2) **BODY AND TEXTURE CHARACTERISTICS.** Wisconsin grade B brick and muenster cheese may be curdy to a definite degree. The graded cheese shall have a fairly uniform distribution of salt. Body and texture standards are shown in the grade B column of Table 10 under s. ATCP 81.60 (2).

(3) **COLOR CHARACTERISTICS.** Wisconsin grade B brick and muenster cheese may have a slight degree of uneven coloration. Muenster cheese may have orange artificially colored surfaces that enhance the traditional appearance of the cheese. Color standards are shown in the grade B column of Table 11 under s. ATCP 81.60 (3).

(4) **FINISH AND APPEARANCE CHARACTERISTICS.** Wisconsin grade B brick and muenster cheese may be slightly less uniform in size and shape and possess slight surface defects, but shall be clean and free from checks or mold. The wrapper or covering may be slightly uneven, but shall adequately and securely envelop the cheese. Allowance shall be made for wrinkles caused by crimping or sealing when vacuum packaging is used. Cured brick cheese may have an overlap of parchment, foil, or other satisfactory packaging material that securely envelops and protects the cheese. Uncured brick cheese and colored or uncolored brick or muenster cheese may be packaged in a vacuum type package or other satisfactory packaging material that securely envelops and protects the cheese. Finish and appearance standards are shown in the grade B column of Table 12 under s. ATCP 81.60 (4).

History: Cr. Register, April, 1993, No. 448, eff. 5-1-93.

Subchapter VII—Swiss or Emmentaler Cheese; Grade Standards

ATCP 81.70 Wisconsin grade A or Wisconsin state brand standards. Swiss or emmentaler cheese labeled or sold as Wisconsin grade A or Wisconsin state brand shall conform to the following standards:

(1) **FLAVOR CHARACTERISTICS.** Wisconsin grade A or Wisconsin state brand Swiss cheese or emmentaler cheese shall have a pleasing and desirable characteristic Swiss cheese flavor consistent with the age of the cheese. The cheese shall be free from undesirable flavors. Flavor standards are shown in the grade A column of Table 13. The presence or absence of flavor characteristics shall be determined organoleptically by taste and smell.

TABLE 13. SWISS (EMMENTALER) CHEESE

| GRADING STANDARDS FOR FLAVOR CHARACTERISTICS | | | | |
|---|---------------------------------|---------|---------|---------|
| IDENTIFIED FLAVOR CHARACTERISTIC IN CHEESE BEING GRADED | GRADE A (Wisconsin State Brand) | GRADE B | GRADE C | GRADE D |
| ACID | | VS | S | D |
| BARNY | | | S | D |
| BITTER | | VS | S | D |
| FEED | | S | D | P |

TABLE 13. SWISS (EMMENTALER) CHEESE – Continued

| GRADING STANDARDS FOR FLAVOR CHARACTERISTICS | | | | |
|---|---------------------------------|---------|---------|---------|
| IDENTIFIED FLAVOR CHARACTERISTIC IN CHEESE BEING GRADED | GRADE A (Wisconsin State Brand) | GRADE B | GRADE C | GRADE D |
| FLAT | | S | D | D |
| FRUITY | | | S | D |
| LIPASE or RANCID | | | S | D |
| METALLIC | | VS | S | D |
| OLD MILK | | | S | D |
| SOUR | | | S | D |
| UTENSIL | | VS | S | D |
| WEEDY | | | S | D |
| WHEY-TAINT | | | S | D |
| YEASTY | | | S | D |

VS = very slight; S = slight; D = definite; P = pronounced; Blank = nondetectable.

(2) BODY CHARACTERISTICS. Wisconsin grade A or Wisconsin state brand Swiss or emmentaler cheese shall be uniform, firm, and smooth. Body standards are shown in the grade A column of Table 14.

TABLE 14. SWISS (EMMENTALER) CHEESE

| GRADING STANDARDS FOR BODY CHARACTERISTICS | | | | |
|---|---------------------------------|---------|---------|---------|
| IDENTIFIED BODY CHARACTERISTIC IN CHEESE BEING GRADED | GRADE A (Wisconsin State Brand) | GRADE B | GRADE C | GRADE D |
| COARSE | | | S | D |
| PASTY | | | S | D |
| SHORT | | | S | D |
| WEAK | | S | D | D |

VS = very slight; S = slight; D = definite; P = pronounced; Blank = condition not present.

(3) EYE AND TEXTURE CHARACTERISTICS. Wisconsin grade A or Wisconsin state brand Swiss or emmentaler cheese shall be properly set and possess well developed, round or slightly oval eyes. The eyes shall be relatively uniform in size and uniformly distributed. The majority of the eyes shall be $\frac{3}{8}$ to $\frac{13}{16}$ inch in diameter. The cheese may have very slight dull, rough and shell eye characteristics. The texture of the cheese may contain very slight checks, picks, and streuble. Eye and texture standards are shown in the grade A column of Table 15.

TABLE 15. SWISS (EMMENTALER) CHEESE

| GRADING STANDARDS FOR EYE AND TEXTURE CHARACTERISTICS | | | | |
|--|---------------------------------|---------|---------|---------|
| IDENTIFIED EYE AND TEXTURE CHARACTERISTIC IN CHEESE BEING GRADED | GRADE A (Wisconsin State Brand) | GRADE B | GRADE C | GRADE D |
| AFTERSSET | | | S | D |
| CABBAGE | | | S | D |
| CHECKS | VS | S | D | D |
| COLLAPSED | | | S | D |
| DEAD | | VS | D | D |
| DULL | VS | S | D | D |
| FROG MOUTH | | S | D | D |

TABLE 15. SWISS (EMMENTALER) CHEESE – Continued

| GRADING STANDARDS FOR EYE AND TEXTURE CHARACTERISTICS | | | | |
|--|---------------------------------|---------|---------|---------|
| IDENTIFIED EYE AND TEXTURE CHARACTERISTIC IN CHEESE BEING GRADED | GRADE A (Wisconsin State Brand) | GRADE B | GRADE C | GRADE D |
| GASSY | | | S | D |
| IRREGULAR | | | S | D |
| LARGE EYED | | | S | D |
| NESTY | | VS | D | D |
| ONE SIDED | | S | D | P |
| OVERSET | | S | D | D |
| PICKS | VS | S | D | D |
| ROUGH | VS | S | D | P |
| SHELL | VS | S | D | D |
| SMALL EYED | | | S | D |
| SPLITS | | | S | D |
| STREUBLE | VS | S | D | D |
| UNDERSET | | S | D | D |
| UNEVEN | | S | D | D |

VS = very slight; S = slight; D = definite; P = pronounced; Blank = condition not present.

(4) FINISH AND APPEARANCE CHARACTERISTICS. Wisconsin grade A or Wisconsin state brand Swiss or emmentaler cheese shall have the following finish and appearance characteristics:

(a) *Swiss cheese containing a rind.* The rind shall be sound, firm and smooth and shall provide good protection to the cheese. The surface of the cheese may contain a very slight amount of mold, but no mold shall have penetrated the interior of the cheese. Finish and appearance standards are shown in the grade A column of Table 16.

TABLE 16. SWISS (EMMENTALER) CHEESE

| GRADING STANDARDS FOR FINISH AND APPEARANCE CHARACTERISTICS | | | | |
|--|---------------------------------|---------|---------|---------|
| IDENTIFIED FINISH AND APPEARANCE CHARACTERISTIC IN CHEESE BEING GRADED | GRADE A (WISCONSIN STATE BRAND) | GRADE B | GRADE C | GRADE D |
| CHECKED RIND | | | S | D |
| HUFFED | | S | D | P |
| MOLD ON RIND SURFACE | VS | S | D | P |
| MOLD UNDER WRAPPER OR COVERING | VS | S | D | P |
| SOFT SPOTS | | | S | D |
| SOILED SURFACE (rind) | | S | D | P |
| SOILED SURFACE (rindless) | | | VS | S |
| UNEVEN | | S | D | P |
| WET RIND | | S | D | D |
| WET SURFACE (rindless) | | S | D | D |

VS = very slight; S = slight; D = definite; P = pronounced; Blank = condition not present.

(b) *Rindless Swiss cheese*. A rindless block of grade A Swiss cheese shall be reasonably uniform in size and well shaped. The wrapper or covering shall adequately and securely envelop the cheese. The wrapper or covering may be slightly wrinkled, but shall be neat, unbroken and fully protect the surface of the cheese. The surface of the cheese may contain a very slight amount of mold, but no mold shall have penetrated the interior of the cheese. Finish and appearance standards are shown in the grade A column of Table 16 under par. (a).

(5) **COLOR CHARACTERISTICS**. Wisconsin grade A or Wisconsin state brand Swiss or emmentaler cheese shall have a natural, attractive and uniform color. Color standards are shown in the grade A column of Table 17.

TABLE 17. SWISS (EMMENTALER) CHEESE

| GRADING STANDARDS FOR COLOR CHARACTERISTICS | | | | |
|--|---------------------------------|---------|---------|---------|
| IDENTIFIED COLOR CHARACTERISTIC IN CHEESE BEING GRADED | GRADE A (Wisconsin State Brand) | GRADE B | GRADE C | GRADE D |
| ACID CUT | | | S | D |
| BLEACHED SURFACE | | S | D | D |
| COLOR SPOTS | | | S | D |
| DULL OR FADED | | | S | D |
| MOTTLED | | | S | D |
| PINK RING | | | S | D |

VS = very slight; S = slight; D = definite; P = pronounced; Blank = condition not present.

History: Cr. Register, April, 1993, No. 448, eff. 5-1-93; am. Tables 13 to 17, Register, January, 1996, No. 481, eff. 2-1-96; CR 99-151: am. (4) (b), Register July 2001, No. 547 eff. 8-1-01; CR 01-057: am. (3) and Table 15, Register June 2002 No. 558, eff. 7-1-02.

ATCP 81.71 Wisconsin grade B standards. Swiss or emmentaler cheese labeled or sold as Wisconsin grade B shall conform to the following standards.

(1) **FLAVOR CHARACTERISTICS**. Wisconsin grade B Swiss or emmentaler cheese shall have a pleasing and desirable characteristic Swiss cheese flavor consistent with the age of the cheese. The cheese may contain a very slight acid, bitter, metallic and utensil flavor. The cheese may contain a slight feed and flat flavor. Flavor standards are shown in the grade B column of Table 13 under s. ATCP 81.70 (1). The presence or absence of flavor characteristics shall be determined organoleptically by taste and smell.

(2) **BODY CHARACTERISTICS**. Wisconsin grade B Swiss or emmentaler cheese shall be uniform, firm and smooth, but may have a slight weak body. Body standards are shown in the grade B column of Table 14 under s. ATCP 81.70 (2).

(3) **EYE AND TEXTURE CHARACTERISTICS**. Wisconsin grade B Swiss or emmentaler cheese shall have well-developed, round or slightly oval shaped eyes. The majority of the eyes shall be $\frac{3}{8}$ to $\frac{13}{16}$ inch in diameter. The cheese may also have various undesirable eye and texture characteristics to a very slight or slight degree for the applicable trait. Eye and texture standards are shown in the grade B column of Table 15 under s. ATCP 81.70 (3).

(4) **FINISH AND APPEARANCE CHARACTERISTICS**. Wisconsin grade B Swiss or emmentaler cheese shall have the following finish and appearance characteristics.

(a) *Swiss cheese containing a rind*. The rind shall be sound, firm, and smooth, and shall provide good protection to the cheese. The cheese shall have no mold penetrating its interior. The cheese may contain various undesirable finish and appearance characteristics to a slight degree for the applicable trait. Finish and appearance standards are shown in the grade B column of Table 16 under s. ATCP 81.70 (4) (a).

(b) *Rindless Swiss cheese*. The wrapper or covering for a rindless block of Swiss cheese shall adequately and securely envelop the cheese. The wrapper or covering may be slightly wrinkled, but it shall be neat and unbroken and shall fully protect the surface of the cheese. The surface of the cheese may contain a slight amount of mold but no mold shall penetrate the interior of the cheese. The cheese may contain various undesirable finish and appearance characteristics to a slight degree for the applicable trait. Finish and appearance standards are shown in the grade B column of Table 16 under s. ATCP 81.70 (4) (a).

(5) **COLOR CHARACTERISTICS**. Wisconsin grade B Swiss or emmentaler cheese may have a slight bleached surface. Color standards are shown in the grade B column of Table 17 under s. ATCP 81.70 (5).

History: Cr. Register, April, 1993, No. 448, eff. 5-1-93; CR 99-151: am. (4) (b), Register July 2001, No. 547 eff. 8-1-01; CR 01-057: am. (3), Register June 2002 No. 558, eff. 7-1-02.

ATCP 81.72 Wisconsin grade C standards. Swiss cheese labeled or sold as Wisconsin grade C shall conform to the following standards.

(1) **FLAVOR CHARACTERISTICS**. Wisconsin grade C Swiss or emmentaler cheese shall have a characteristic Swiss cheese flavor consistent with age of the cheese. The cheese may contain various disrating flavor characteristics to a slight or definite degree for the applicable flavor. Flavor standards are shown in the grade C column of Table 13 under s. ATCP 81.70 (1). The presence or absence of flavor characteristics shall be determined organoleptically by taste and smell.

(2) **BODY CHARACTERISTICS**. Wisconsin grade C Swiss or emmentaler cheese shall have a uniform body. The cheese may contain various disrating body characteristics to a slight or definite degree for the applicable trait. Body standards are shown in the grade C column of Table 14 under s. ATCP 81.70 (2).

(3) **EYE AND TEXTURE CHARACTERISTICS**. Wisconsin grade C Swiss or emmentaler cheese may contain various disrating eye and texture characteristics to a slight or definite degree for the applicable trait. Eye and texture standards are shown in the grade C column of Table 15 under s. ATCP 81.70 (3).

(4) **FINISH AND APPEARANCE CHARACTERISTICS**. Wisconsin grade C Swiss or emmentaler cheese shall have the following finish and appearance characteristics.

(a) *Swiss cheese containing a rind*. The rind shall be sound and shall provide good protection to the cheese. The cheese shall have no mold penetrating its interior. The cheese may contain various disrating finish and appearance characteristics to a slight or definite degree for the applicable trait. Finish and appearance standards are shown in the grade C column of Table 16 under s. ATCP 81.70 (4) (a).

(b) *Rindless Swiss cheese*. The wrapper or covering of rindless Swiss cheese shall adequately and securely envelop the cheese. The wrapper or covering may be wrinkled, but shall be unbroken and fully protect the surface of the cheese. The surface of the cheese may contain definite mold but no mold shall penetrate the interior of the cheese. The cheese may contain various disrating finish and appearance characteristics to a very slight, slight or definite degree for the applicable trait. Finish and appearance standards are shown in the grade C column of Table 16 under s. ATCP 81.70 (4) (a).

(5) **COLOR CHARACTERISTICS**. Wisconsin grade C Swiss or emmentaler cheese may have various disrating color characteristics to a slight or definite degree for the applicable trait. Color standards are shown in the grade C column of Table 17 under s. ATCP 81.70 (5).

History: Cr. Register, April, 1993, No. 448, eff. 5-1-93.

ATCP 81.73 Wisconsin grade D standards. Any damaged Swiss or emmentaler cheese which is marketable for use as

human food except for the damage, and cheese which does not meet the requirements of any of the higher grades under this subchapter shall qualify for the Wisconsin grade D classification.

History: Cr. Register, April, 1993, No. 448, eff. 5-1-93.

Subchapter VIII — Wisconsin Cheese Logotype

ATCP 81.80 Official logotype design and use.

(1) The official logotype shall consist of a miniature outline map of the boundaries of Wisconsin, with the words “WISCONSIN CHEESE” appearing across the upper two-thirds of the map in large bold faced type or lettering larger than any other words or figures in the logotype, and extending partially beyond the outside boundaries of the outline map. The figures “100%”, in fine-line type or lettering no more than half the height of the words “WISCONSIN CHEESE”, shall be centered in the intervening space between the words “WISCONSIN CHEESE” and the top of the map. In the lower half of the map there shall appear the words “made in”, to be followed immediately below with the word “WISCONSIN”, in bold faced type or lettering approximately one-half the size of the words “WISCONSIN CHEESE”. The words “made in” shall be in bold faced, lower case type or lettering. The factory or other identification number assigned to persons authorized to use the logotype shall be centered in the intervening space between the word “WISCONSIN” and the bottom line of the map, in type or lettering approximately one-half the size of the word “WISCONSIN”. All type or lettering shall be easily readable and so spaced and designed as to present a symmetrical appearance within the logotype, as illustrated in the official model set forth below:



(2) The official logotype shall be proportionate in size to the size of any package or container label or labeling on which it is to be used.

(3) The official logotype may be affixed to and used only on cheese manufactured in this state entirely from milk produced under and meeting sanitary and quality standards equal to or greater than those established under ss. 97.24 and 97.52, Stats., or rules adopted thereunder for the production and distribution of milk, and which otherwise conforms to all applicable standards and requirements of ch. 97, Stats., relating to the manufacturing, labeling and sale of cheese.

History: Cr. Register, May, 1977, No. 257, eff. 6-1-77; renum. from Ag 88.02, Register, April, 1993, No. 448, eff. 5-1-93.

ATCP 81.81 Registration. (1) No person shall use or affix the official logotype on any cheese, or its wrapper or container, without first registering with the department and obtaining a permit authorizing its use in connection with the manufacture, labeling and sale of Wisconsin cheese. Applications for registration shall include the business name and address of the manufac-

turer or labeler and such other information concerning use of the logotype as required by the department. Persons authorized to use the official logotype shall be issued an identification number for use in the logotype. In the case of a manufacturer, the number shall be the same as the factory number previously assigned. The number assigned shall be centered directly below the word “WISCONSIN” in the bottom portion of the map as specified under s. ATCP 81.80.

(2) Permits shall be issued without the payment of any fee and be valid for a period of 2 years after date of issuance, and may be renewed for like periods upon expiration thereof and qualification of the applicant. The department shall grant or deny a permit application within 20 business days after the application is filed with the department, provided that the application is accompanied by all requisite information and documentation. Permits may be denied, suspended or revoked if the logotype is used contrary to requirements of this chapter or the permit holder uses or aids or abets the use of the logotype on cheese not manufactured in this state. Registrants shall at all times keep the department informed of any changes in plant operations affecting use of the logotype.

(3) (a) The official logotype may be affixed to and used on cheese manufactured in this state meeting the grade standards of “WISCONSIN CERTIFIED PREMIUM GRADE AA,” “WISCONSIN GRADE A” or “WISCONSIN STATE BRAND” if the cheese is one for which grade standards have been adopted under this chapter. The official logotype may also be used on cheese, manufactured in this state, which is given a score of 92 or better under par. (b) if the cheese is one for which no grade standards have been adopted by the department. The official logotype may not be used on any cheese other than cheese identified under this paragraph. Cheese shall be graded by graders licensed under s. 97.17, Stats.

(b) Cheese for which no separate grade standards have been adopted by the department shall be scored on basis of a 100 point scale in accordance with weighted values as specified herein for each of the separate factors to be considered in determining the quality of the cheese. Points shall be deducted according to the degree to which defects are found in the quality factors affecting the cheese. Cheese shall be scored on basis of the following weighted point value factors:

| | |
|---------------------|-----------|
| Flavor | 40 points |
| Body & Texture | 35 points |
| Color | 10 points |
| Makeup & Appearance | 10 points |
| Salt | 5 points |

(c) Testing techniques and standards used in grading cheese for which standards have been adopted by the department shall be used in scoring cheese for which no grade standards have been adopted.

(d) Cheese on which the logotype is to be used shall be manufactured in this state entirely from milk produced under and meeting sanitary and quality standards equal to or greater than those established under ss. 97.24 and 97.52, Stats., or rules adopted thereunder for the production and distribution of milk, and which conforms to all applicable standards and requirements of ch. 97, Stats., relating to the manufacturing, labeling and sale of cheese.

History: Cr. Register, May, 1977, No. 257, eff. 6-1-77; am. (3), Register April, 1978, No. 268, eff. 5-1-78; am. (3) (a) and (d), Register, November, 1979, No. 287, eff. 12-1-79; am. (2), Register, December, 1985, No. 360, eff. 1-1-86; renum. from Ag 88.03 and am. (1) and (3) (a), Register, April, 1993, No. 448, eff. 5-1-93; am. (3) (a), Register, January, 1996, No. 481, eff. 2-1-96.

ATCP 81.82 Official logotype use. (1) **FACTORY MARKINGS.** (a) Rind cheese shall be plainly marked at the factory with the official logotype stamped or imprinted on the surface of the rind, or a label attached thereto, and also on the outer surface of the box or carton containing the cheese, or any label attached to such box or carton.

(b) Rindless cheese shall be plainly marked at the factory with the official logotype stamped or imprinted on the inner wrap or sleeve, and also on the outer surface of the box or carton containing the cheese, or any label affixed or attached to such box or carton.

(2) PACKAGED CHEESE. Cheese cut, packaged or wrapped and offered for sale at wholesale or retail shall be plainly marked with the official logotype stamped or imprinted on the wrapper of the cheese or a label affixed or attached thereto.

History: Cr. Register, May, 1977, No. 257, eff. 6-1-77; renum. from Ag 88.04, Register, April, 1993, No. 448, eff. 5-1-93.

ATCP 81.83 Records. All persons registered and authorized to use the official logotype shall keep records of all cheese on which the official logotype is used, to include the source, quantity and type of cheese on which it is used, the place where such cheese is cut, packaged and labeled, and points to which cheese bearing the logotype is shipped for ultimate sale or distribution. Permit holders furnishing logotype labels to out-of-state buyers shall keep records of the quantity of labels included with each bulk shipment. Records shall be kept for a period of one year and be made available for department inspection.

History: Cr. Register, May, 1977, No. 257, eff. 6-1-77; renum. from Ag 88.05, Register, April, 1993, No. 448, eff. 5-1-93.

Subchapter IX – Baby Swiss Cheese; Standard of Identity and Labeling

ATCP 81.91 Baby Swiss cheese; product description and preparation. (1) DESCRIPTION. Baby Swiss cheese is the food prepared by the process under sub. (2) or by any other process which produces a finished cheese having the same physical and chemical properties as that produced under sub. (2). Baby Swiss cheese has round, well-formed holes or eyes developed throughout the cheese. The minimum milkfat content of baby Swiss cheese is 45% by weight of the solids. The maximum moisture content is 43% by weight, as determined by a method that complies with s. ATCP 80.32. Baby Swiss cheese shall be held at the point of manufacture for 60 days prior to distribution, or be made from pasteurized milk. If pasteurized milk is used, the phenol equivalent value of 0.25 grams of baby Swiss cheese shall not exceed 3 micrograms.

(2) PREPARATION. To prepare baby Swiss cheese, the dairy ingredients specified in s. ATCP 81.92 (1) (a) shall be brought to a temperature of 90° F. Bacterial cultures or enzymes specified in s. ATCP 81.92 (1) (b) shall be added to the dairy ingredients, in order to subject them to the action of lactic acid and propionic acid. One or more of the clotting enzymes specified in s. ATCP

81.92 (1) (c) shall be added to the dairy ingredients, in order to coagulate or set the dairy ingredients into a semisolid mass. The semisolid mass shall be cut into curd particles by a one-quarter inch curd knife. The whey shall be drained from the semi-solid curds. Water shall be added to the curds, and the temperature shall be raised to 106° F as the curds and water are stirred. The temperature of 106° F shall be maintained and the stirring shall continue until the curds become firm. The curds shall be transferred to hoops or forms and pressed until the desired shape and firmness are attained. The cheese shall then be salted by immersing it in a saturated salt solution for 2 to 72 hours, depending on the desired degree of saltiness.

History: Cr. Register, January, 1996, No. 481, eff. 2-1-96.

ATCP 81.92 Ingredients. (1) The following ingredients shall be used in the manufacture of baby Swiss cheese:

(a) Dairy ingredients consisting of milk, skim milk, nonfat milk, or cream, used alone or in combination, provided that the final cheese product meets the fat and moisture requirements set forth under s. ATCP 81.91 (1).

(b) Cultures or enzymes of animal, plant or microbial origin, used for acid production and for curing, flavor and texture development.

(c) Clotting enzymes, consisting of rennet or other enzymes of animal, plant or microbial origin, used to set the dairy ingredients to a semisolid mass.

(2) The following optional ingredients may be used in the manufacture of baby Swiss cheese:

(a) Coloring.

(b) Calcium chloride, used as a coagulation aid. If used, the amount of calcium chloride, calculated as anhydrous calcium chloride, shall not exceed 0.02% by weight of the dairy ingredients.

(c) Antimycotic agents, applied to the surface of slices or cuts in consumer-sized packages, used to retard mold growth.

History: Cr. Register, January, 1996, No. 481, eff. 2-1-96.

ATCP 81.93 Nomenclature and label declaration. The name of the food described in s. ATCP 81.91 (1) shall be baby Swiss cheese. The product label shall include an ingredient declaration setting forth, in descending order of predominance by weight, the common or usual name of each ingredient used in the food. Enzymes of animal, plant or microbial origin may be declared as enzymes. If the product is made from pasteurized milk, it shall be so labeled.

History: Cr. Register, January, 1996, No. 481, eff. 2-1-96.